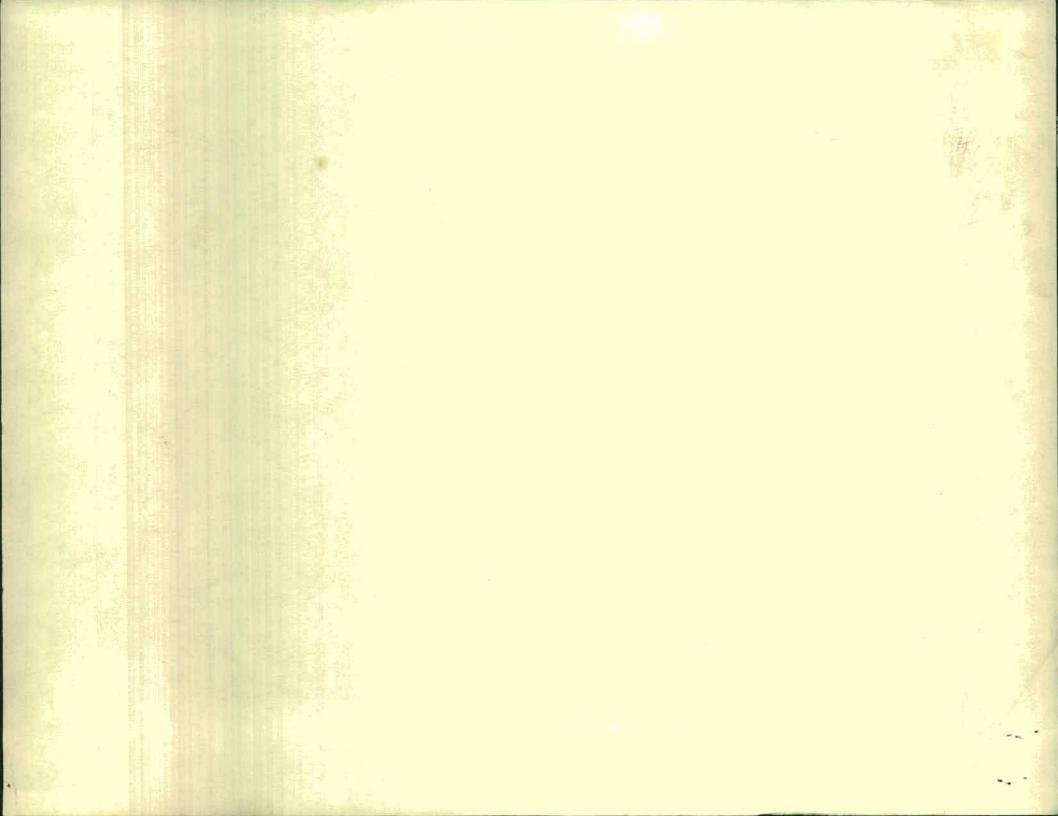
Dart Aerospace Ltd. Friday, 29/09/2006 9:12:34 AM Linda Lacelle User **Process Sheet** : SADDLE FITTING, FWD (SUTBOARD/INBOARD) **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer : 28778 - 2 Job Number : 10530 **Estimate Number** : D2571 Part Number : NIA P.O. Number : D2571 REV E S.O. No. : NIA **Drawing Number** : 29/09/2006 This Issue : N/A Project Number Prsht Rev. : NIA E : MACHINED PARTS Drawing Revision Type First Issue : MA Material : 28444 Previous Run Each : 06/10/2006 **Due Date** Written By Checked & Approved By I 02.10.02 Re-format; Change to Dwg Rev. D & Comment incorporated D2572KJ Additional Product Job Number: Description: Machine Or Operation: Seq. #: 7075-T7351 8.25X7.75X2.5 D6101007 1.0 4.0000 Each(s) 1,0000 Each(s)/Unit Total: Comment: Qty.: 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length 06109129 J.6 Batch No: 13 25 354 HAAS CNC VERTICAL MACHINING #1 HAAS1 2.0 Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. 38718 Double check by: J. F. 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension_Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 06/09/29 5-Tumble to remove sharp edges. MILLING CONV. 3.0 Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572



Friday, 29/09/2006 9:12:34 AM Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 28778

Part Number: D2571

Job Number:



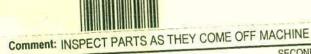
Seq. #:

Machine Or Operation:

Description:

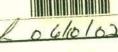
4.0

INSPECT PARTS AS THEY COME OFF MACHINE









5.0

6.0





Comment: SECOND CHECK

HAND FINISHING1

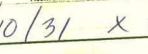
HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

POWDER COATING



7.0





Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

INSPECT POWDER COAT/CHEMICAL CONVERSION

QC3 8.0



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1



PACKAGING RESCURCE



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

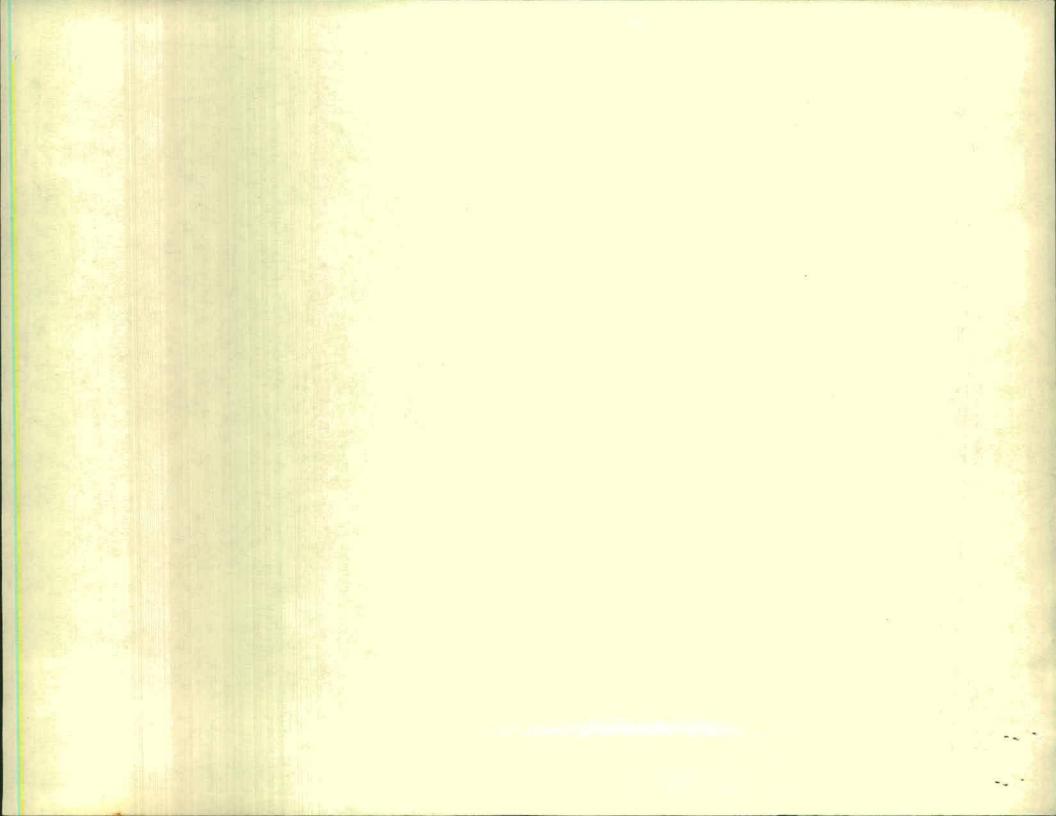
10.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



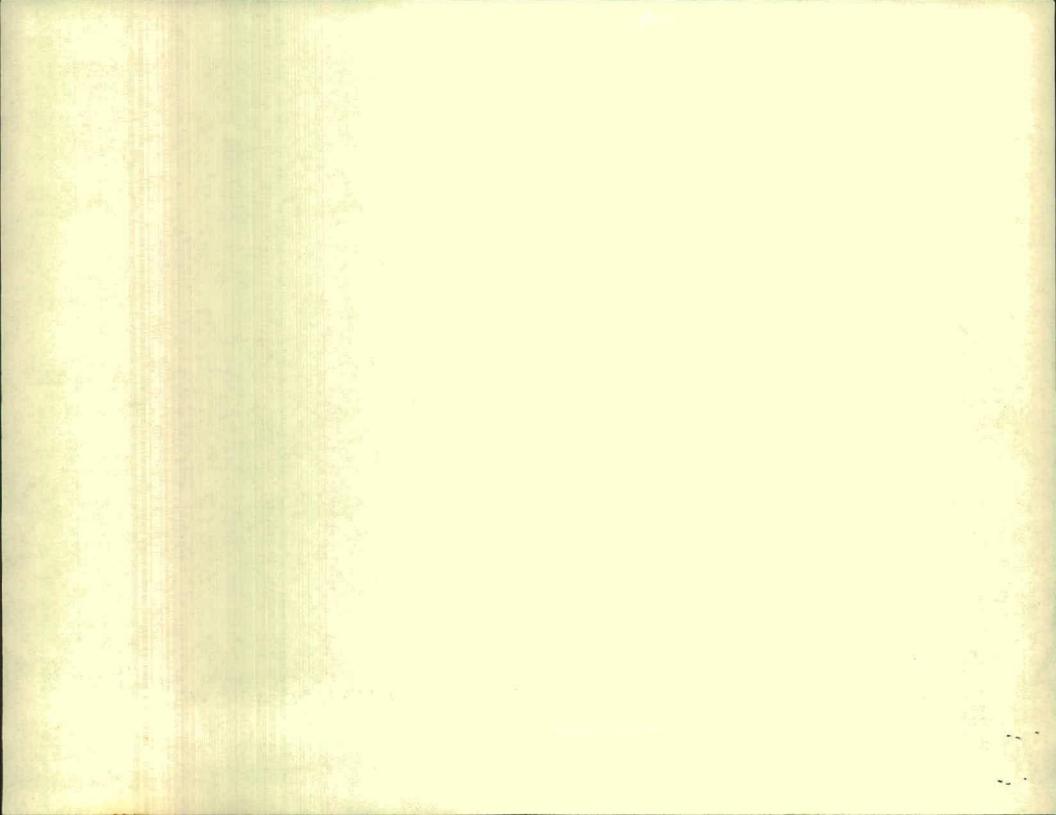
	Dar	t Aer	ospa	ce Ltd
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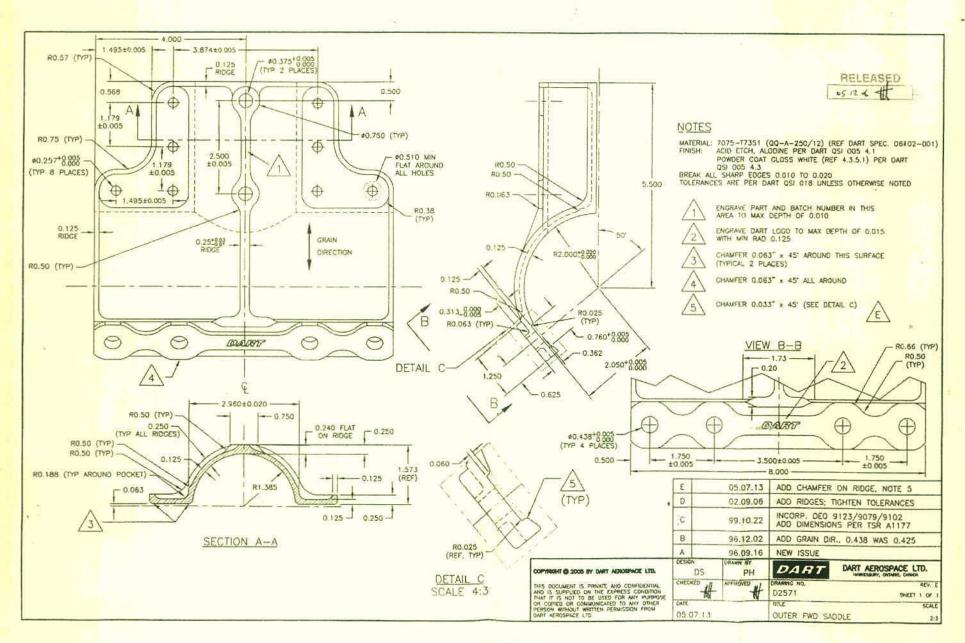
W/O:		WORK ORDER CHAN	NGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-10-13	4.0	W/O split for I suddle because of NCR.	7	d-10.13	1	и	106-10-13
							1

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	_ Date: <u>06/11/25</u>
			QA: N/C Closed:	Date:

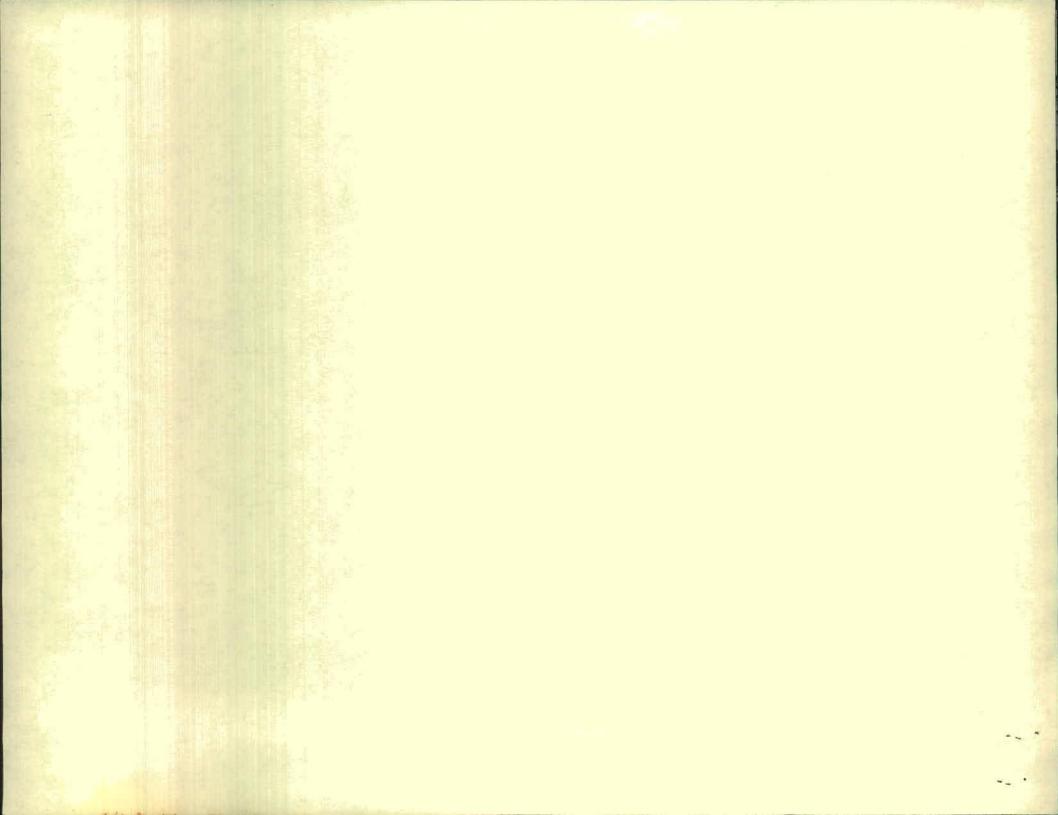
NCR:		Wo	ORK OF	DER NON-CONFORMANCE	(NCR)			
DATE STEP		Description of NC		Corrective Action Section B		Varification		\$
DAIL		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
66/10/02		-7 A Flat was machied on Ridges by skip trope politing hole affect was wrong. -> wrong trop was wad to machie D. n "AD" 0.250 was machied 10 0.234 (0.016" winder	MANDE	Buff Flat men as round of As possible. Pont acceptable.	06/141	8 0610-13	Mille	10.13
		toolwas changed. only or DZS71 effected.	1		,		2	
								Ť

NOTE: Date & initial all entries





REFERENCE ONLY



DART AEROSPACE LTD	Work Order:	20178
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Red	orded Actu	al Dimensio	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443	D T8682	0.439	0.439		0.439		
В	1.745	1.755		1,749	1.749	1.749	1.749		
С	3.495	3.505		3.499	3.499	3,499	3.494		
D	1.745	1.755		1.749	1.749	1.750	1.750		
E	7.990	8.010		7.995	7.998	7.999	7.999		
F	0.490	0.510		0.507	0.502	0.502	0.502		
G	0.257	0.262	□T8683	0.358	0.258	0.258	0.258		
Н	0.375	0.380	DT8084	0.377	0 37-6		0 376		
1	0.490	0.510		0.497	0.500	6,498	0.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578	7	0.567	0.567	0:567	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.498		
N	2.495	2.505		2.500	2.499	2.500	2 500		
0	3.869	3.879		3.873	3.872	3.877	3.872		
Р	0.115	0.135		0.126	0.126	0126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.254	6.255	8.253	0.254		
S	0.115	0.135		0.122	0.123	0126	0.127		
T	0.178	0.198		0/88	0.188	0.188	0.188		
U	2.940	2.980		2.962	2.960	2.960	2960		
V	0.230	0.250		0.240	0.236	0.239	0.238		
W	0.115	0.135		0.119	0.122	0.121	0.120		
X	0.308	0.313		0313	6.311	0.310	0.311		
Y	0.760	0.765		0,760	8.760	0.760	0.760		
Z	0.352	0.372		0.364		0364	0.36.2		
AA	0.470	0.530		0.500	0.500	0.506	0.200		
AB	0.615	0.635		0.635			0.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.2-47	0.251	0.253		
AE	1.375	1.395		1.388	1-388	1.386	1.387		
AF	0.115	0.135		0.130	0.128	0.128	0.130		
AG	0.240	0.280		Q-25b	0.250	0.252	0.245		
AH	0.240	0.260		0.250	0.245	0,252	0.251		
Al	2.000	2.020		2.002	2.002	2.001	2.001		
AJ	0.023	0.043		0,035	0.035	0.635	0.035		
	Ac	cept/Reje	ct						

					_
ſ	Measured by:	me	Audited by	EP	
Ì	Date:	0660102	Date:	06/10/29	
- 1	Dollo.	01001			

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.09.24	Re-format; Added Rev. D	KJ	
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	28778
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Red	corded Actu	ial Dimensio	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443	DT8682	0.439	8.439				
В	1.745	1.755		1.749	1.749				
C	3.495	3.505		3 499	3.499				
D	1.745	1.755		1.749	1.744				
E	7.990	8.010		7.999	7.999				
F	0.490	0.510		0.302	0.503				
G	0.257	0.262	DT8683	1.258	0,258				
Н	0.375	0.380	DT8684	0 376	0.376				
1	0.490	0.510		0.500	0.499				
J	1.174	1.184		1-174	1,179				
K	0.558	0.578		0.567	0.567				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.500	1.500				
N	2.495	2.505		2500	2.500				
0	3.869	3.879		3.872	3.872				170
Р	0.115	0.135		0.04	0.124				
Q	0.115	0.135		6:133	0.135				
R	0.240	0.260		0.253	0.253				
S	0.115	0.135		0.127	0.124				
Т	0.178	0.198		0.138	B.183	E.			
U	2.940	2.980		2,960	2.962				
٧	0.230	0.250		0.746	0.237				
W	0.115	0.135		0.122	0.120			7	
X	0.308	0.313		c. 311	0311	0310			
Y	0.760	0.765		0.760	0.760	0.765			
Z	0.352	0.372		0.363	5-360				
AA	0.470	0.530		6,500	0,500				
AB	0.615	0.635		0.628	0.628				
AC	0.053	0.073		0.063	6.063				
AD	0.240	0.260		0.252	0.247				
AE	1.375	1.395		7,385	1.388				
AF	0.115	0.135		0.130	0.125				
AG	0.240	0.280		0.245	0.745				
AH	0.240	0.260		0.232	0.250				
AI	2.000	2.020		2.000	2.002				
AJ	0.023	0.043		0.035	0.035				
		ept/Reje	ct	0.0.33					

Measured by:	Inl	KA	Audited by	5.1	- 1 .	0
Date:	06/10/0	+ ddrd29	Date:	06	0/10/29	

Date	Change	Revised by	Approved
	New Issue	RF	
02.09.24	Re-format; Added Rev. D	KJ	
02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
05.05.05	Added dimension AI	KJ/RF	1
05.12.05	Added dimension AJ	KJ/JLM X	Gul
	02.09.24 02.10.11 05.05.05	New Issue 02.09.24 Re-format; Added Rev. D 02.10.11 Re-format; Added DT8682, DT8683, DT8684 05.05.05 Added dimension AI	New Issue RF 02.09.24 Re-format; Added Rev. D KJ 02.10.11 Re-format; Added DT8682, DT8683, DT8684 KJ 05.05.05 Added dimension AI KJ/RF

